

Work Order ID 56650

March 3, 2010 1:13:00 PM

Page 1

Item ID: D3781-043

Accept

Revision ID:

Item Name: Armrest Cushion Assembly

Start Date: 03/03/2010 Start Qty: 2.00

Required Date: 08/03/2010 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date: 10-3-03

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3781

D

100

0.00



Purchasing

Purchasing

Memo

Issue P/O:

11457
Ship with D3785-1 SUPPORTING PLATE
Material: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT) AND COVER
D3781-5/D3785-1 ASSEMBLY WITH SURREY SILVER SUNSET
UPHOLSTERY FABRIC P/N SY-11. Zipper P/N: AI-Z021
THREAD: MIL-VT-295 TYPE2 CLASS A, GREY NYLON THREAD, 4-6
STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS.
Possible Supplier: AEROTEX INTERIORS INC.
Material release note is required

0.00

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Packaging

Memo

0.00

10-3-03
(5)

Rec'd 3/10 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56650

March 3, 2010 1:13:00 PM



Page 2

Item ID: D3781-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Armrest Cushion Assembly

Start Date: 03/03/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 08/03/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

800/03/16



QC

Memo

0.00

Quality Control

⑤

130

Identify as per dwg & Stock Location: 180

0.00



Packaging

Memo

0.00

Packaging

10/03/17 ⑤

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/17

MF

10-3-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

March 3, 2010 1:13:03 PM

Page 1

Work Order ID: 56650

Parent Item: D3781-043

Parent Item Name: Armrest Cushion Assembly

Comments: IPP RevA: New issue DD verified by:EC IPP Rev:B 09-05-15 As per ECN09-593P JLM Verified By:EC

Start Date: 03/03/2010

Required Date: 08/03/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3785-1

Manufactured

No

110

Each

5.0000

2.0000 5



Bracket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

55493

5

MF 10-3-17

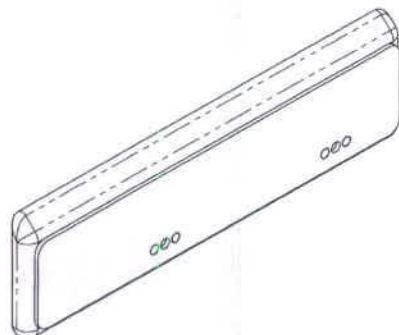
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

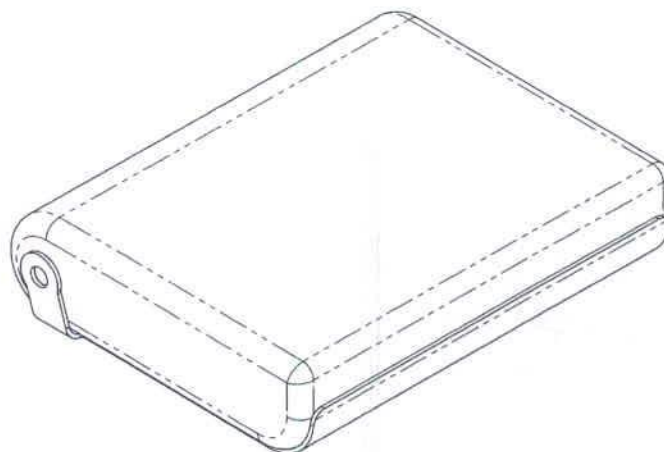
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NOTE: Date & initial all entries



D3781-041 LATERAL CUSHION ASSY
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



D3781-043 ARMREST CUSHION
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 56650

PL 10-03-3

RELEASED
[Signature]

D	REDESIGNED BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.21
C	REDESIGNED FOR COMPATIBILITY WITH BHT 204 SEATS	MB	08.11.10
B	REDESIGNED; ADDED DETAIL A (ZN B7-1)	MB	08.07.15
A	NEW ISSUE	MB	08.04.29
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	<i>[Signature]</i>		
MFG. APPR.			
APPROVED	<i>[Signature]</i>		
DE APPR.			
DATE	09.05.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3781

REV. D
SHEET 1 OF 6

TITLE
CUSHION ASSEMBLY

SCALE
NTS

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

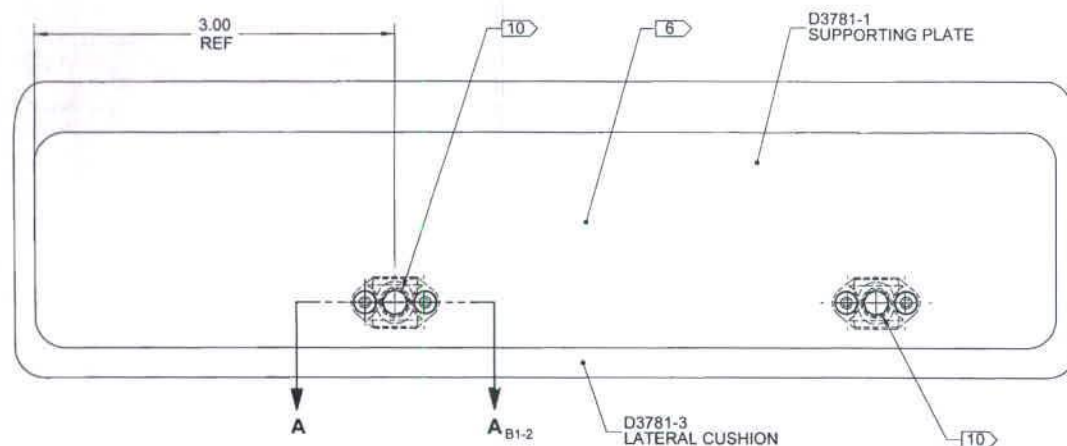
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

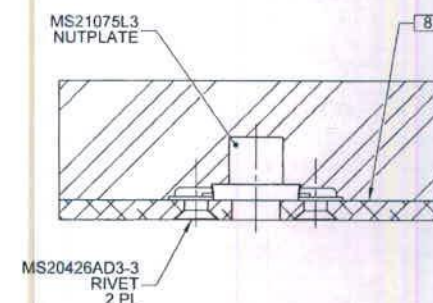
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
1	X	D3781-041	CUSHION ASSEMBLY
11	1	D3781-1	SUPPORTING PLATE
12	1	D3781-3	LATERAL CUSHION
22	2	MS21075L3	NUT PLATE (OR MS21075-3)
23	A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY FABRIC
24	A/R	1300	3M SCOTCH-GRIP ADHESIVE
25	4	MS20426AD3-3	RIVET



D3781-041 LATERAL LATERAL CUSHION ASSEMBLY
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



D3781-041 NOTES:

- 1) MATERIAL: COVER D3781-1/-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111.
BOND FABRIC USING 3M 1300/1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS
POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.18 lbs
- 8) BOND D3781-3 CUSHION TO D3781-1 SUPPORTING PLATE USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 9) IT IS ACCEPTABLE TO RELIEVE D3781-3 CUSHION WHERE THE NUTPLATES ARE LOCATED TO ENSURE PROPER CONTACT WITH D3781-1 SUPPORTING PLATE
- 10) HOLES MUST BE FREE OF ADHESIVE AND FABRIC

RELEASED
29/07/14

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO. D3781	REV. D
MFG. APPR.	ND		SHEET 2 OF 6
APPROVED	ANT	TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
DATE	09.05.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR CONSTRUCTION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

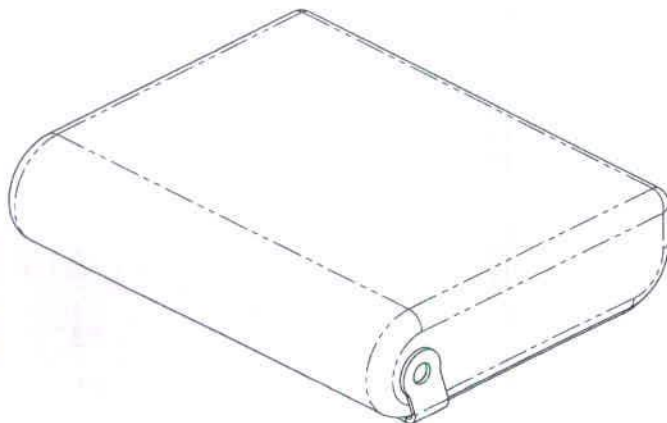
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

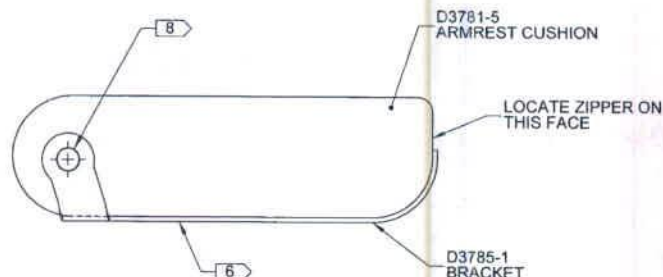
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3781-043 LATERAL ARMREST CUSHION BASE ASSY
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3781-043	ARMREST CUSHION ASSEMBLY
11	1	D3785-1	BRACKET
12	1	D3781-5	ARMREST CUSHION
21	A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY FABRIC
22	A/R	1300	3M SCOTCH-GRIP ADHESIVE

D3781-043 NOTES:

- 1) MATERIAL: COVER D3781-5/D3785-1 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111.
THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS
ZIPPER P/N: AI-2021
POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-043" USING FINE POINT PERMANENT INK MARKER AFTER RECEIVING
- 7) WEIGHT: 1.14 lbs
- 8) DO NOT COVER HOLES WITH FABRIC

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	AD	D3781	SHEET 3 OF 5
APPROVED	W	TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
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RELEASED
09/07/21 WHP

w/o 56650

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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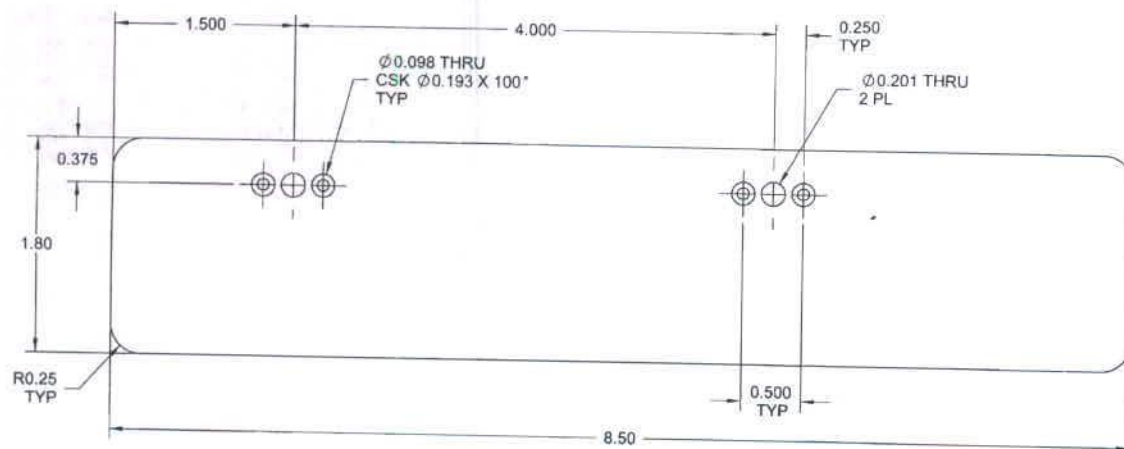
NOTE: Date & initial all entries

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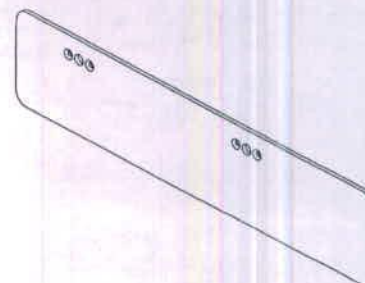
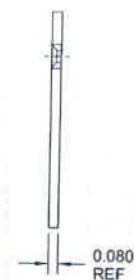
D

C

B



D3781-1 SUPPORTING PLATE



D

C

B

D3781-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF. DART SPEC. M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.12 lbs

RELEASED
09/04/14

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	13	DRAWING NO.	D3781	REV. D
DRAWN	4/5	TITLE	CUSHION ASSEMBLY	SCALE
CHECKED	4/5			NTS
MFG. APPR.	4/5			
APPROVED	4/5			
DE APPR.	4/5			
DATE	09.05.21			

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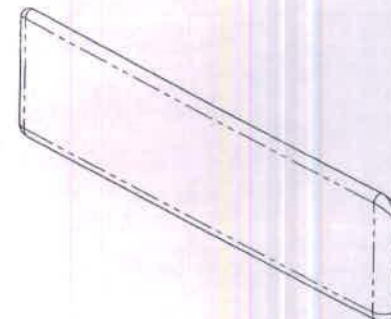
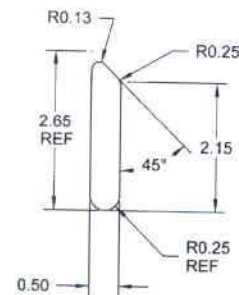
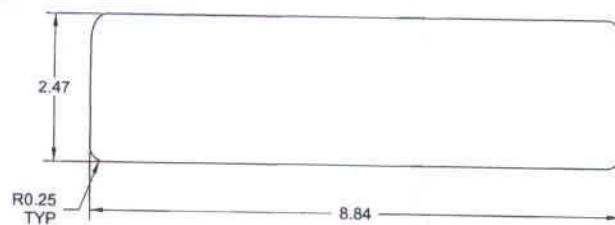
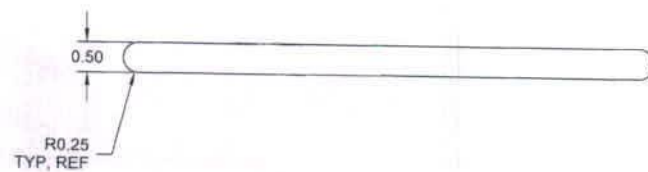
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3781-3 LATERAL CUSHION

D3781-3 NOTES:

- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.

RELEASED
9/6/21 MP

WLC56650

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED	<i>SS</i>	DRAWING NO. D3781
MFG. APPR.	<i>MP</i>	REV. D
APPROVED	<i>MP</i>	SHEET 5 OF 6
DE APPR.	<i>MP</i>	TITLE CUSHION ASSEMBLY
DATE	09.05.21	SCALE NTS

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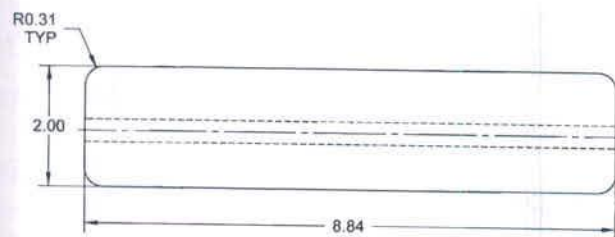
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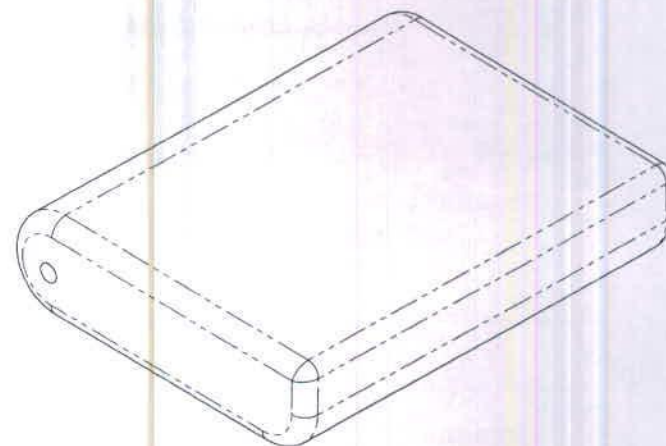
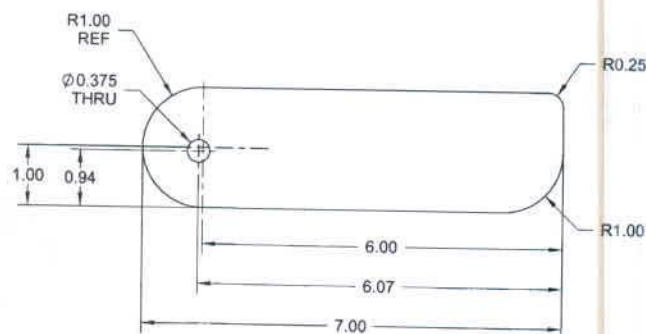
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3781-5 ARMREST CUSHION



D3781-5 NOTES:

- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.67 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.

RELEASED

12/05/650

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. D
MFG APPR.		D3781	SHEET 6 OF 6
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DE APPR.		CUSHION ASSEMBLY	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO11457

Purchase Order Date 03/03/2010

PO Print Date 04/03/2010

Page Number 1 of 1

Order From :

VC-AER003

AEROTEX INTERIORS INC.
#24-2333 18TH AVENUE N. E.
CALGARY, AB T2E 8T6
CA

REVISED

Contact Name
Vendor Phone 403 295 8770
Vendor Fax 403 313 0793
Vendor Account Nbr

Buyer Brigitte Golden
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3781-043P	armrest cushion ass'y	17/03/2010 Yes	5.00 Each	FedEx Overnight	\$175.0000	\$875.00

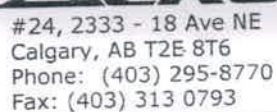
Special Inst: As per DWG: D3781 Rev D
B# 56650
Mat: Skandia HR150 Oiktfian (4.6
KBS/Cu Ft) and cover D3781-1 ass'y
with surrey silver sunset upholstery
fabric P/N SY-11. Zipper P/N: AI-Z021
Thread: MIL-VT-295 Type 2 class A,
Grey nylon Thread, 4-6
stitches per inch, use 1/2" min
backstitch, no loose threads.

PO Total: \$875.00

Change Nbr: 2

Change Date: 04/03/2010

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



Date	Packing Slip#
08/03/2010	6206

Ship To
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Customer Phone	Customer Fax
613.632.5200	613.632.1053
Ship Via	Courier Acct No.
FedEx	15179324-0

Invoice To

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship Date	P.O. No.
08/03/2010	PO11457

Description	ALT. Part Number	Part Number	Qty
ARMREST CUSHION ASSY. GST On Sales		D3781-043P	5

Thank you for doing business with Aerotex Interiors!

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GST/HST No. 139110308



- Unit 24, 2333 - 18 Ave NE, Calgary AB T2E 8T6 - Phone: (403) 295 -8770 - Fax: (403) 313 - 0793 -

CERTIFICATION OF CONFORMANCE

Customer Purchase Order:

PO11457

Our Work Order:

6206

THIS IS TO CERTIFY THAT THE FOLLOWING MATERIALS HAVE BEEN USED IN THE WORK ORDER STATED ABOVE:

MATERIAL - SURREY SILVER SUNSET

FOAM - HR150

HAS BEEN FABRICATED TO ESTABLISHED SPECIFICATION TO CONFIRM WITH FAR 27.853(a), 29.853(a) and DWG. D3756/D3755

SOLD TO:

DART AEROSPACE LTD., 1270 ABERDEEN STREET, HAWKESBURY, ON K6A 1K7

AUTHORIZED REPRESENTATIVE

A large, stylized handwritten signature in black ink, written over a horizontal line.



- Unit 24, 2333 - 18 Ave NE, Calgary AB T2E 8T6 - Phone: (403) 295-8770 - Fax: (403) 313-0793 -

CERTIFICATION OF CONFORMANCE

Customer Purchase Order:
Our Work Order:

PO11457
6206

THIS IS TO CERTIFY THAT THE FOLLOWING MATERIALS HAVE BEEN USED IN THE WORK ORDER STATED ABOVE:

MATERIAL - SURREY SILVER SUNSET

FOAM - HR150

THREAD - MIL-V-T-295, CLASS A, TYPE II

HAS BEEN FABRICATED TO ESTABLISHED SPECIFICATION TO CONFIRM WITH FAR 27.853(a), 29.853(a) and DWG. D3756/D3755

SOLD TO:

DART AEROSPACE LTD., 1270 ABERDEEN STREET, HAWKESBURY, ON K6A 1K7

AUTHORIZED REPRESENTATIVE

A handwritten signature in black ink, consisting of a large, stylized 'A' followed by a cursive flourish, is written over a horizontal line.

